Dart Aerospace Ltd. Manday, 7/16/2007 2:41:51 PM **Process Sheet Drawing Name** : HIGH AFT X-TUBE 412 : CU-DAR001 Dart Helicopters Services Customer Job Number : 33539 : 10559 **Estimate Number** : D412664203 Part Number : JIA P.O. Number S.O. No. : 1 D412-664-243 REV D **Drawing Number** : 7/16/2007 This Issue : N/A Project Number Prsht Rev. : LANDING GEAR **Drawing Revision** First Issue Material Previous Run Each : 8/5/2007 Qty: 1 Um: Due Date Written By Checked & Approved By Reformat; Added D3189-1 K/DS Comment : Est Rev:E Remove Coments on Pick List JLM Est Rev:F 06-03-29 per ECN 886 EC Est Rev:G 06.12.08 As per Rev D JLM Est Rev:H 07-04-30 **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: KS 07.07.30 DOCUMENT CONTROL 1.0 DC Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006 D6009129 Crosstube Material 20 1.0000 Each(s) Who some vow extrusion Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Qty Part number Description Batch 1 D6009-129 Crosstube **B3**5668 Check OD = 3.500"; ID = 2.250" MORI SEIKI MORI SEIKI CNC LATHE LARGE 3.0 Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

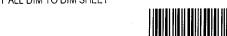
2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

4.0 QC1

INSPECT ALL DIM TO DIM SHEET





Comment: INSPECT ALL DIM TO DIM SHEET

51 oxlight

Monday, 7/16/2007 2:41:51 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 33539 Part Number: D412664203 Job Number: Description: Seq. #: **Machine Or Operation:** MORI SEIKI CNC LATHE LARGE 5.0 MORI SEIKI Comment: MORI SEIKI CNC LATHE LARGE 1-Turn second side as per Folio FA166 2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243 Inside of Cuff(Donot engrave on outside of tube) 6.0 INSPECT ALL DIM TO DIM SHEET QC1 Comment: INSPECT ALL DIM TO DIM SHEET SECOND CHECK 7.0 QC8 Comment: SECOND CHECK LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 JD 7-10-22 1-Polish entire outside surface of crosstube INSPECT WORK TO CURRENT STEP QC5 9.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING 10.0 ULTRA SONIE Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 11.0 Comment: Inspect work & Chemical conversion Coat

Monday, 7/16/2007 2:41:51 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 33539 Job Number: Description: Seq. #: Machine Or Operation: BENDING MACHINE BENDING 12.0 Comment: BENDING MACHINE Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010 DIMENSIONAL CHECK OF X-TUBES 13.0 **CHECK OF X-TUBES** Comment: DIMENSIONAL LANDING GEAR RESOURCE 1 14.0 LANDING GEAR 1 Comment: | ANDING GEAR RESOURCE 1 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 15.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 JD7-10-25 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 16.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION INSPECT WORK TO CURRENT STEP 17.0 QC5 Comment: INSPECT WORK TO CURRENT STEP OUTSIDE SERVICES -LG 18.0 INTRA SONE Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 038Or CL07/10/26 1) Issue P/O: 4916 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

Monday, 7/16/2007 2:41:51 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 33539 Job Number: Description: Seq. #: Machine Or Operation: PACKAGING RESOURCE #1 19.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order. INSPECT WORK TO CURRENT STEE 20.0 QC5 Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 SPRAY PAINTING 21.0 Comment: SPRAY PAINTING 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2 INSPECT SPRAY PAINT 22.0 QC14 Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches Rubber Cushion (per sq ft) 23.0 0.0492 sf(s)/Unit 0.0492 sf(s)Comment: Qtv.: Total: Rubber Cushion (per sq ft) .630" x5.70" x2pcs 24.0 D2856600 Abrasion Strip Comment: Qtv.: Total: 1.7640 f(s) 1.7640 f(s)/Unit Pick: Description Qty Part number 2 D2856-600(Cut to 10.090") Abrasion Strip 25.0 D28961 Support Comment: Qty.: Total: 1.0000 Each(s) 1.0000 Each(s)/Unit Pick: Qty Part number Description Batch 1 D2896-1 Support

Monday, 7/16/2007 2:41:51 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 · Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 33539 Job Number: Description: Seq. #: Machine Or Operation: Chafing Shield 26.0 D31891 Comment: Qty.: 2.0000 Each(s)/Unit 2.0000 Each(s) Total: Pick: Description Batch Qty Part number 2 D3189-1 Chafing Sheild MS2192028 Clamp(per MIL-DTL-8783C) 27.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part number Description Batch 4 MS21920-28 Clamp clamp(per MIL-DTL-8783C) 28.0 MS2192030 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: clamp(per MIL-DTL-8783C) batch: 100154 LANDING GEAR 1 29.0 Time. Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203 1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs Batch: M104677 6398 Magnobond Expiry Date: 04/08 2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb. 30.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 31.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit

Date: User:		day, 7/16/200 Johnston	07 2:41:51 PM		Process SI	neet	,
, ,	Customer:	CU-DAR001	Dart Helicopters Service	es		ring Name: HIGH AFT X-TUB	E 412
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Jo	b Number:	33539			Pa	t Number: D412664203	
Job N	umber:						
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	32.0	AN640A			Bolt		111111111111111111111111111111111111111
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<u> </u>	-33.0	AN641A	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		Bolt	2	
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de	Comme	ent: Qty.:	2.0000 Each(s)/Unit	Total :	2.0000 Each(s)		
		Bolt	M/04427		•		· /
	34.0	Batch: AN960JD616	1101901		Washer	<u> </u>	
					, .*·		
4	Comme	nt: Qty.:	I8.0000 Each(s)/Unit	Total :	18.0000 Each(s)		
		Washer Batch:	M1-5/28				
	35.0	MS21042L6		****	Nut		
V	Comme	•	6.0000 Each(s)/Unit	Total :	6.0000 Each(s)		
		Nut Batch:	1104374			(27/11/0	8 (1)
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	Comme	nt: INSPEC	T 100% KITS FOR CC	MPLETEN		6 Hulo	9
_	37.0	PACKAGING	1 		PACKAGING RESC	DURCE #1	
						<u> </u>	
	Comme		SING RESOURCE #1	a nor DDD	D440 664 000		
		identity a	ind pack for shipping a	is pei PPP	D412-004-203		
		******Ens	ure tube is not packag	ed if curing	time is less than	12 hrs, see step 27 for appl	lication time & date
				11,	-09 Q	10 Am	
		Time & d	ate of packaging:	/- //		10 44	
		Location:					٠.
		PPP Rev	/		>0	$\sqrt{\chi}$	
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Date: User: Monday, 7/16/2007 2:41:51 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33539

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description:

38.0

QC21

FINAL INSPECTION/W/O RELEASE



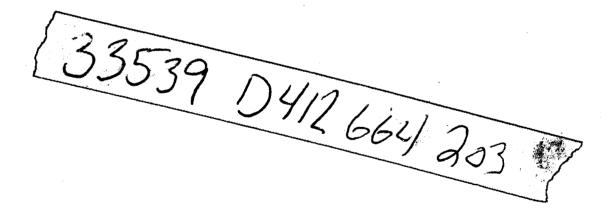
Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W Dt.11.09



DART AEROSPACE LTD	Work Order:	33539
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

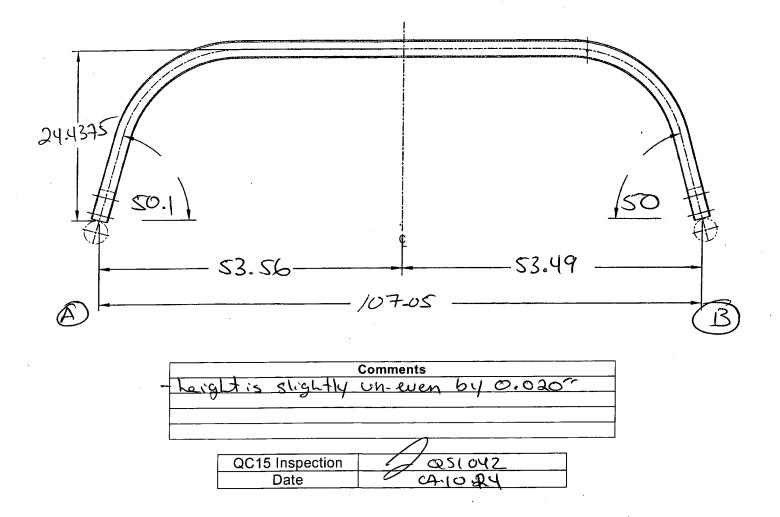
lr Dra	nspection Sheet awing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
····	2.684	+0.005/-0.000	2.688	<i>\(\)</i>			
	2.748	+0.005/-0.000	2.754	//			
	2.884	+0.005/-0.000	2.886				
	3.019	+0.005/-0.000	3.022	\(\sigma\) "			y ·
	3.163	+0.005/-0.000	3.166	/,			
	3.308	+0.005/-0.000	3.313				
⋖	3.429	+0.005/-0.000	3.431	//			
SIDE	2.990	+0.005/-0.000	2.995	~			
S	2.618	+0.005/-0.000	2.624				
	0.200	+/-0.010	-210	/			
	R0.063	+/-0.010	1.063	/			
	R0.500	+/-0.010	1.500				
	4.971	+/-0.030	4.975				
				/			
	2.684	+0.005/-0.000	2.687				
	2.748	+0.005/-0.000	2.752				Mark
	2.884	+0.005/-0.000	2.887	/			
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	3.308	+0.005/-0.000	3.310				
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SIDE	2.990	+0.005/-0.000	2.995	/			
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	124.09	+/-0.020	124.1	V	1		, , , , , , , , , , , , , , , , , , ,

Measured by:	J.L	Audited by:		Prototype Approval:	N/A
Date:	07/10/15	Date:	157-10-21	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.06.16	New Issue	(P/O D412-664-203)	KJ/JLM	
В	06.03.09	Dwg Rev updated		KJ/JLM	
С	07.05.08	Tolerance updated	for dimension 4.971	KJ/JLM	

DART AEROSPACE LTD	Work Order:	33539
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

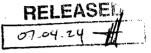
Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM , ,	1
В	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM cx	fr
	·		, ()	



DESIGN		DRAWN BY	DART AEROSPACE LTD					
	PH	PH	HAWKESBURY, ONTARIO, CANADA					
CHECK	ED 🕜	APPROVED	DRAWING NO.	REV. D				
	41	4	D412-664-243 SHEET	1 OF 3				
DATE			TITLE	SCALE				
07.0	3.09		CROSSTUBE ASSEMBLY (412 HI AFT)) NTS				
Α		01.10.17	NEW ISSUE					
		05.00.04	ADD LIGHTS FOR COMPATABILITY					



07.0)3.09	CROSSTUBE ASSEMBLY (412 HI AFT) N	m
Α	01.10.17	NEW ISSUE	
В	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
С	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

Qty	Part Number	Description
Х	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
- -	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

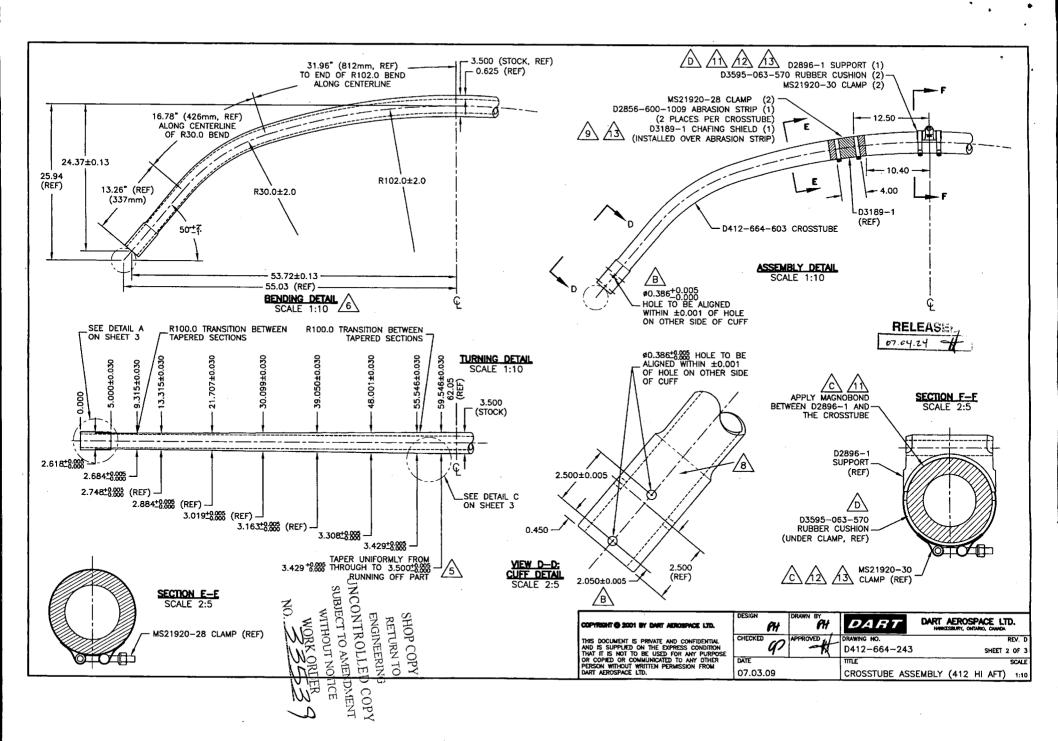
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- MATERIAL: MANUFACTURED FROM D6009-129 FINISHED LENGTH = 124.09±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART 005 4.2
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART, BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE NONTROLLED COPY
 BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MAPKS ADE UNACCEPTABLE
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

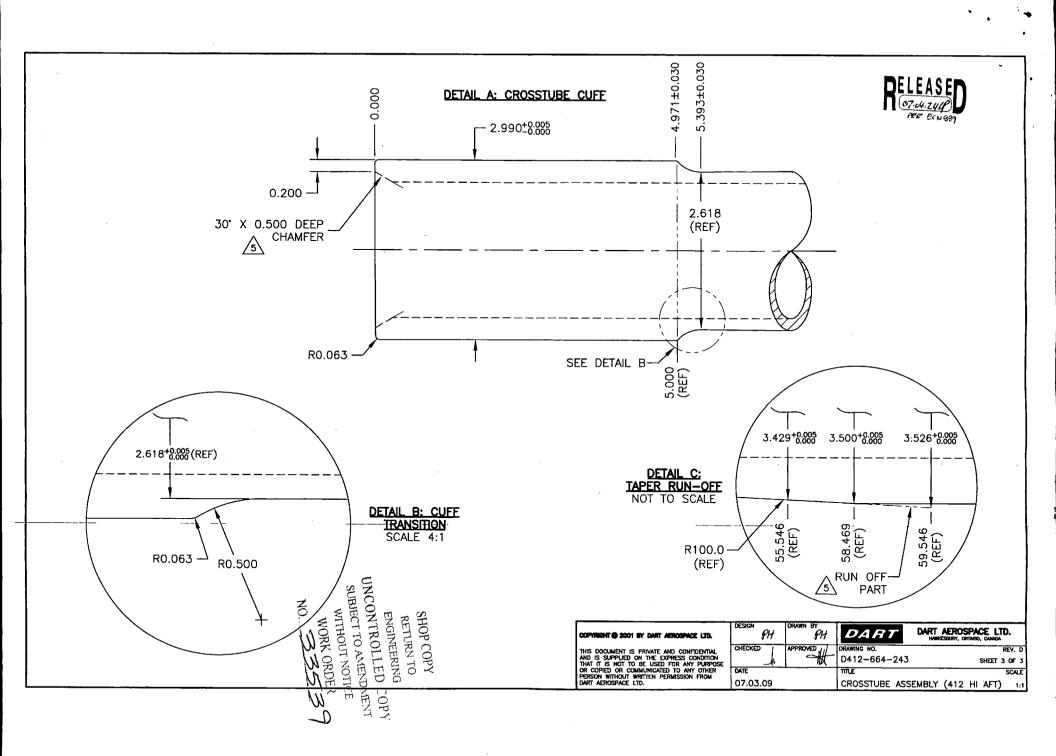
SHOP COPY RETURN TO ENGINEERING SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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LIQUID PENETRANT TEST REPORT

P- 09852

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ATTENTION	Linda	acelle			Acuren Job No.	188-	07-0112	74j		
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	Howk	eskery, 6	5N (WORK LOCATION	Hei	Kes bur	1		
	1122	7			ACCEPTANCE STO	ASTMIL	17/05I-07	REV./DA	TE 2	5
PROJECT	Flourege	Thing of F	25+ 0	n 212/3	205 High	FED X-	TUB=+Hi	L AFT		E41.2
ITEM(S) EXAMINED	T-8#33	540 P.H	FD41361	42-2	杨子,	33.53	7 + 757-	£ 55	24	3505%
	T-30B# 12	5106 A	ke-J	7.R#	349,28 8	PART #	-02136	1410	, ,,,,	
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PENETRANT REMOV	1 1 1	MINIMUM DRY TII				MEDO	TE-ATR		<u> </u>	
DEVELOPER TYPE	NON AQU	MINIMUM DWELL JEOUS AQUEO		DRY MIN. I	LIGHT METER S/N			CAL DU	E DATE	
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hat all descriptions, comme epresentations or warrantie	ents und expressions of opiness. Acuren Group Inc. is no	nion reflect the opinions or o ot assuming any responsibili	observations of Acu ities of the owner/o	ren Group Inc. bas perator and the ow	ed on information and ass ner/operator retains comp	sumptions supplie olete responsibilit	d by the owner/operator of the state of the engineering, ma	and are not inten nufacture, repair	ded nor can they	be construed as 📲
tandard of Care		nc. In no event shall Acuren								
a performing the services p applied, is made or intended		. uses the degree, care and s	kill ordinarily exer	cised under similar	circumstances by others	performing such	services in the same or si	milar locality. N	o other warranty	, expressed or
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_		PRINT		Jan Stranger	SIGNATURE		REPORT		THE RESERVE	
ECHNICIAN (SIGNAT	TURE):	anel		<u></u>			REVIEWED BY:			
JAME (PRINT):		totten	MAK		2 ^{NO} TEOLINI			NAME		INITIALS
	CGSB LE	1 ST TECHNICIAN VEL - SNT L	EVEL	CGSB LEVEL	2 ^{NO} TECHNICIAN SNT LE	EVEL				
	CGSB RE	G. No33	37	CGSB REG.	No					



LIQUID PENETRANT TEST REPORT

P- 09853

#COVEIA	Page Of,
CLIENT DART HEROSPACE	DATE CET 30-07 TIME AM ET PM 0
ATTENTION Linda Lacelle	ACUREN JOB NO. 188-07-01
IDDRESS 1270 Averdeen St.	PO/WO No. 4016
VIII RESEARCH CIVIL	WORK LOCATION DART AEROSPICE
	ACCEPTANCE STD. ASTM 1417/05/CSTREV./DATE 2005
PROJECT LPT-Flourescat on 2/2/2051	LICH FED X+TUBE THIGH AFT-X-TUBE 412
TEM(S) EXAMINED TOPH A - 34928 + 35106 3	5056:35055:33540:33539
TENIO, EXAMINED	
OB DESCRIPTION PROCEDURE NO. LTCORREV./DATE	TECHNIQUE NO. 2LT-XXXX-XXX REV./DATE
DUIS / 1106-3 / D219 66 NIO	MATERIAL ALOCLINES Alumin THICKNESS
180-107	xternal surface
SCOPE WET LIT Floores em 100/00	<u>X</u> , O, V (3, C)
Test Details	
	WATER WASH DI SOLVENT REMOVABLE DI POST EMULSIFIED
TAME V PRONID MAC LASTE V	BLACK LIGHT S/N SILS DOUTPUT > 1000 µW/cm2 DAMBIENT < 2 fc
ENE STORY	LIGHTING EQUIP.
ENETRALIT ICHIOVEL	OTHER CALDEDATE AT 7-08 LIGHT METER S/N CAL DUE DATE
DEVELOPER SKD - S.2 MINIMUM DWELL TIME 10 MIN. DEVELOPER TYPE NON AQUEOUS DAQUEOUS DRY	EIGHT METER ON
TEST SURFACE	
SURFACE CONDITION AS GROUND AS WELDED	☐ MACHINED ☐ SHOT BLASTED
SURFACE TEMPERATURE □ < - 4°C/ 20°F □ - 4°C/ 20°F TO 10°C/50°F	☑ 10°C/50°F το 52°C/125°F ☐ > 52°C/125°F
RESULTS- (METRIC IMPERIAL)	
THE COMMENTS ACCEPT REJECT	
Allabore tens were = re-	inspected of terribles I 10%
- scratches were removed	->(Seekenst#01352),/
No relevant indication	xnotedia time of inspection
AND THE RESIDENCE OF THE PARTY	
scope of Services	the properties of the properties services It is expressly understood
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under	no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood used on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as
epresentations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the or idea or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the	
Standard of Care in particular to the provided of the control of the performing the services provided. Activen Group Inc. uses the degree, care and skill ordinarily exercised under similar to the performing the services provided.	
mplied, is made or intended by Acuren Group Inc.	
SIGNATURES	DTD# 27W/
CLIENT REPRESENTATIVE PRINT	SIGNATURE DTR # 2/466
TECHNICIAN (SIGNATURE).	REPORT
TP-DIAK	REVIEWED BY: Name INITIALS
VAME (PRINT): 1 ST TECHNICIAN	2 ^{MO} TECHNICIAN
CGSB LEVEL CGSB LEVEL CGSB LEVEL CGSB REG. NO 3367 CGSB REG	